

WHAT IS CLAIMED IS:

1 1. A breathable footwear piece, the breathable footwear piece
2 comprising:
3 a base section, wherein the base section includes an upper and a sole; and
4 wherein the upper includes a substantially horizontal portion and a
5 substantially vertical portion, and wherein the substantially horizontal portion is a solid
6 portion, and wherein a plurality of ventilators are formed in the substantially vertical portion.

1 2. The breathable footwear piece of claim 1, wherein liquid conductors
2 are formed around each of the plurality of ventilators.

1 3. The breathable footwear piece of claim 2, wherein the liquid
2 conductors are attached to the upper.

1 4. The breathable footwear piece of claim 2, wherein the liquid
2 conductors are formed as part of the upper.

1 5. The breathable footwear piece of claim 1, wherein the base section is
2 molded of a continuous piece of foam material.

1 6. The breathable footwear piece of claim 5, wherein the plurality of
2 ventilators in the form of holes are formed in the upper as part of molding the base section.

1 7. The breathable footwear piece of claim 5, wherein the foam material is
2 manufactured using a resin.

1 8. The breathable footwear piece of claim 7, wherein the resin is mixed to
2 exhibit an expansion coefficient, and a contraction coefficient.

1 9. The breathable footwear piece of claim 8, wherein a combination of
2 the expansion coefficient and the contraction coefficient is between 1.46 and 1.58,
3 inclusively.

1 10. The breathable footwear piece of claim 1, wherein the sole comprises a
2 bottom surface and a support base, and wherein the support base includes a raised pattern
3 where a foot contacts the support base.

1 11. A breathable workshoe, the breathable workshoe comprising:
2 an upper;
3 a sole; and
4 wherein the upper includes at least one ventilator surrounded by a liquid
5 conductor.

1 12. The breathable workshoe of claim 11, wherein the upper and the sole
2 are formed as a single part.

1 13. The breathable workshoe of claim 12, wherein the single part is
2 manufactured from a foam material.

1 14. The breathable workshoe of claim 11, wherein the liquid conductor is
2 formed as part of the upper.

1 15. The breathable workshoe of claim 11, wherein the liquid conductor is
2 attached to the upper.

1 16. A method for manufacturing a breathable workshoe, the method
2 comprising:
3 providing a mold, wherein the mold provides an outline of an upper and a sole,
4 and wherein the upper includes the upper includes a substantially horizontal portion and a
5 substantially vertical portion, and wherein the substantially horizontal portion is a solid
6 portion, and wherein a plurality of ventilators are formed in the substantially vertical portion;
7 screwing a volume of resin into the mold, wherein the resin sets in the form of
8 a footwear piece;
9 opening the mold; and
10 removing the footwear piece.

1 17. The method of claim 16, wherein the outline of the upper includes
2 liquid conductors formed around each of the plurality of ventilators.

1 18. The method of claim 16, wherein the method further comprises:
2 air cooling the footwear piece.

1 19. The method of claim 16, wherein the footwear piece expands when the
2 mold is opened, and contracts when the footwear piece is cooled.

1 20. The method of claim 19, wherein the combination of expansion and
2 contraction is approximately 1.51.